

Work Order ID 68255

Monday, April 11, 2011 10:31:55 AM



Page 1

Item ID: D4081-1

Revision ID:

Item Name: Bushing

Start Date: 4/11/2011 Start Qty: 30.00

Required Date: 4/14/2011 Req'd Qty: 30.00

Reference:

Accept



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date: 4-11-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4081

A

100

0.00



Hardinge

Hardinge CNC Lathe Small

Memo

Turn as per Dwg and Folio FA928

DWG REV: A

FOLIO REV: A

DEBURR

0.00

11.4.11

10

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

11.4.11

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

B.A 11/04/12

10

0

Memo

0.00

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QS1005 4.1

0.00

10 *[Signature]* 11/04/12

Memo

0.00

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

10 *[Signature]* 11/04/12

Memo

0.00

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Page 3

Item ID: D4081-1

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Setup Start



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Stop



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Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 121

0.00

11/11



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

4/11/11

11/4/12

CMF

11-04-12

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, April 11, 2011 10:32:01 AM

Page 1

Work Order ID: 68255



Parent Item: D4081-1



Parent Item Name: Bushing


Start Date: 4/11/2011

Required Date: 4/14/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP REV:A NEW ISSUE 10-05-04 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.375W.058 		Purchased	No			100	f	120.0000	0.1041	3.287368		11.4.11	
6061-T6 RD Tube .375 x.058W													

Location

MAT014

115901 ✓

116920

116939

Loc Qty

120

12

108

Loc Code

1.1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
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W/O:		WORK ORDER CHANGES					
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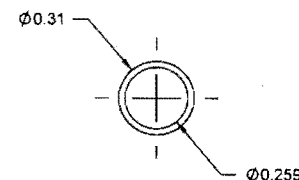
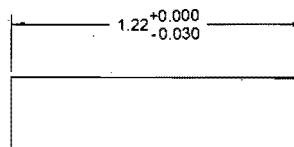
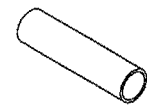
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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 68255
R/ 11-04-11



D4081-1 BUSHING

RELEASED
 2010-09-07
MD

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 TUBING
 PER WW-T-700/6 OR AMS4080 OR AMS4082
 OR QQ-A-200/8 OR QQ-A-225/8
 REF DART SPEC M6061T6T0.375W.058
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN	<i>KB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4081 TITLE BUSHING	<i>KB</i>	10.02.08
DRAWN	<i>KB</i>			
CHECKED	<i>KB</i>			
MFG. APPR.	<i>KB</i>			
APPROVED	<i>KB</i>			
DE APPR.	<i>KB</i>			
DATE	10.02.08			

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